Work Order ID 117311

117311

June-16-14 10:54:49 AM

Item ID: D4920-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: End Fitting

Start Date: 6/16/14 **Start Qty:** 1.00 *1*

Required Date: 6/16/14 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference: PART MARKING

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** [signature] **Date:** 14-06-16 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4920	REV A								
105		0.00							
105									
Purchasing	**Memo**	0.00							
Purchasing	PULL FROM STK: 1 X D4920-3 B112021 SEND TO P & L PRINTING FOR PART MARKING PO 24622					CL 14/06/17			
108	Receive & Inspect for Damage & Mat'l Certs	0.00							
108									
Packaging	**Memo**	0.00							
Packaging									
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	**Memo**	0.00							
Quality Control									

N/A already engraved on Heat

u

Item ID: D4920-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: End Fitting
Start Date: 6/16/14 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 6/16/14 **Req'd Qty:** 1.00 *1* **Customer:**
Reference: PART MARKING

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Identify as per dwg & Stock Location:_____	0.00							
115									
Packaging	**Memo**	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control									

6.6.20

Picklist Print

June-16-14 10:54:49 AM

Work Order ID: 117311

117311

Parent Item: D4920-3

D4920-3

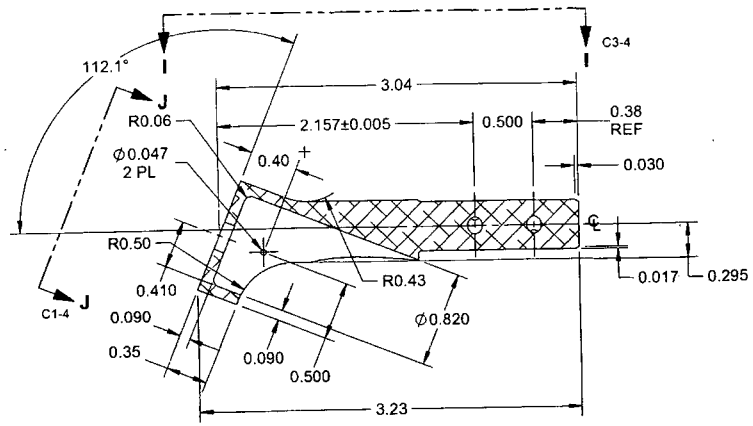
Parent Item Name: End Fitting

Start Date: 6/16/14 **Required Date:** 6/16/14

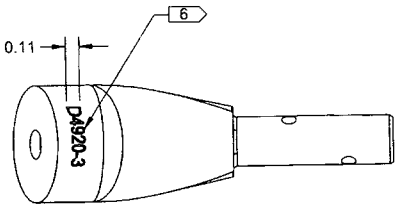
Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

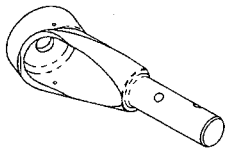
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4920-3		Manufactured	No				Each	0.0000		1			
D4920-3 End Fitting									**	11 2021			

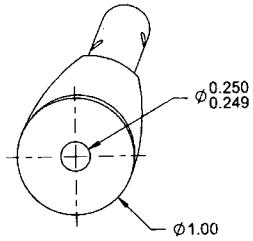


SECTION F-F B7-2

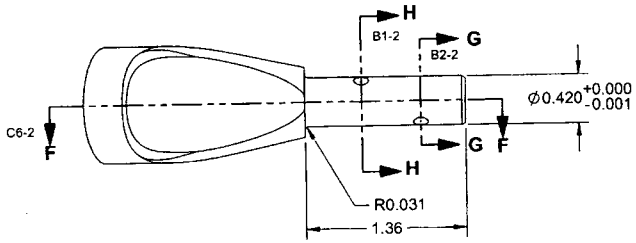


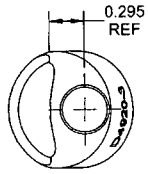
AUXILIARY VIEW I-I D5-2

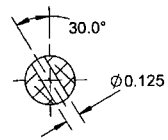




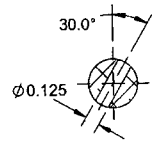
VIEW J-J D7-2







SECTION G-G B5-2



SECTION H-H B6-2

D4920-3 END FITTING

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
7) WEIGHT: 0.17 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

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WITHOUT NOTICE
WORK ORDER
NO. 117311 MLS
14-06-16

APPROVED

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4920 REV. A
MFG. APPR.	JLM	SHEET 2 OF 2
APPROVED	HS	TITLE END FITTING SCALE NTS
DE APPR.	DS	
DATE	13.12.15	

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